

Date: Thursday, 3/13/2008 10:18:49 AM  
 User: Kim Johnston

## Process Sheet

SPLIT

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 37918  
 Estimate Number : 10256  
 P.O. Number :  
 This Issue : 3/13/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 1/1 Type : MACHINED PARTS  
 Previous Run : 37746  
 Drawing Name : MOUNTING LUG  
 Part Number : D22303  
 Drawing Number : D2230 REV F  
 Project Number : N/A  
 Drawing Revision : F  
 Material :  
 Due Date : 4/10/2008 Qty: 100 Um: Each  
 Written By :  
 Checked & Approved By : 08 03 13  
 Comment : Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

10 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 7.1715 f(s)

Lug Extrusion

D2423

Batch: B33310 C08/03/17

20 BAND SAW BAND SAW



Comment: Band Saw

Cut D2423 extrusion to 0.82"

Batch: MA  
meter to cut mat'l

30 HAAS1 HAAS CNC VERTICAL MACHINING #1

C08/03/17

(100)

Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio D2230-3

Check for crack while loading into the machine.

Issue P.O. 5918  
machine per drawing D2230 Rev F

40 QC2

Receive & inspect parts as they come off machineensure EJC attached

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

50 QC5 SECOND CHECK



Comment: SECOND CHECK

inspect level 508/04/2149  
count  
749





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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 37918

Part Number: D22303

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

*CB 08/04/22 (49)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*FL 08/04/24 (49)*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*ml 08 04 25*

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

*AS 08-04-25*

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

*AS BR 08-04-25 (49)*

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*ST 476*

*AS 08/04/29 x49*

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/04/30*

Job Completion



*mf 08-04-29*

37918  
D22303  
25/04/2008  
S.117  
#1 08.40  
#2 322.0  
#3 MINS 30  
#4







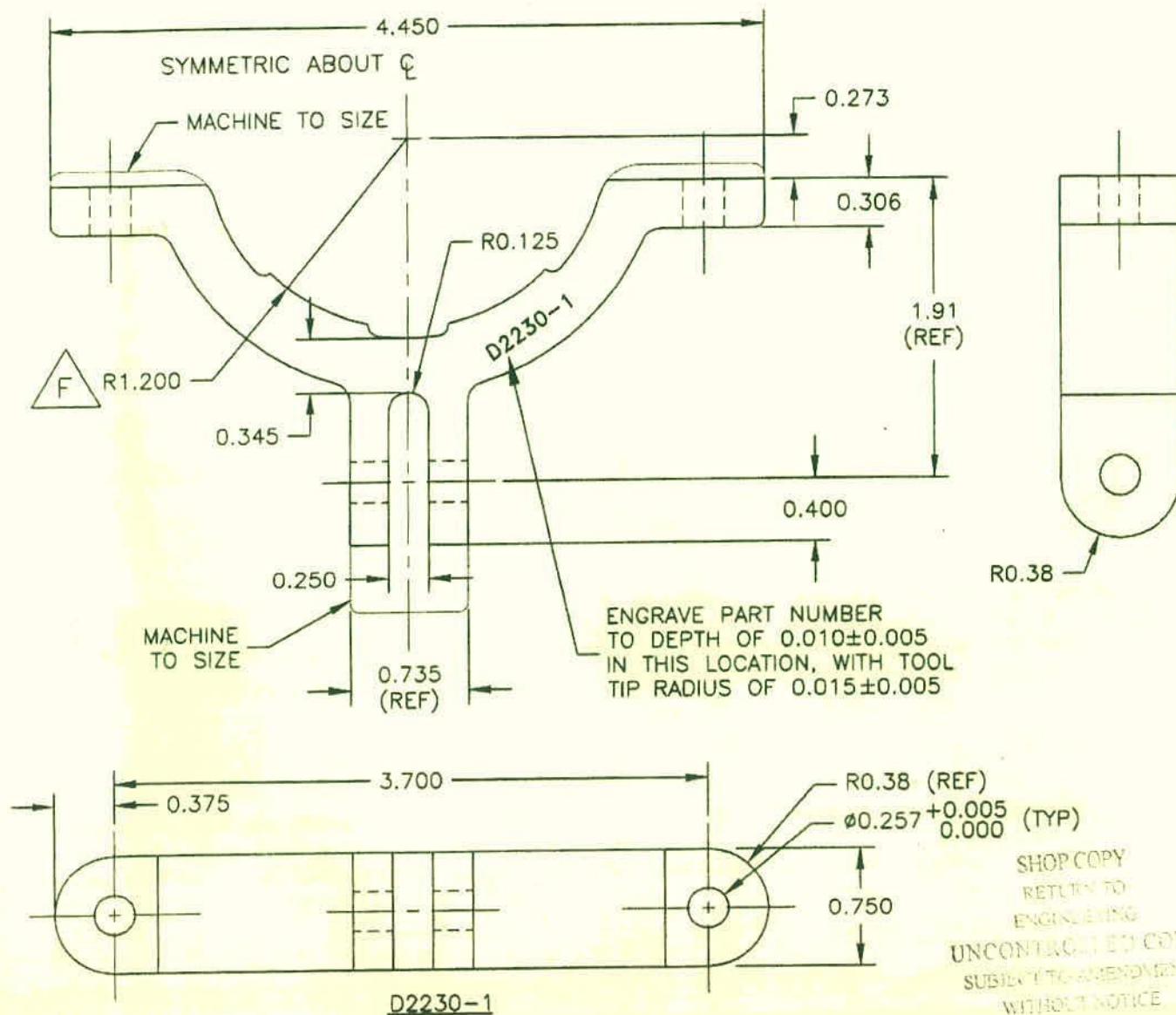






RELEASED  
89-12 21 05

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 1 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1
C	94.03.30	RE-DESIGN	
D	95.01.04	RE-DESIGN	
E	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN; R1.200 WAS R1.100	



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37918

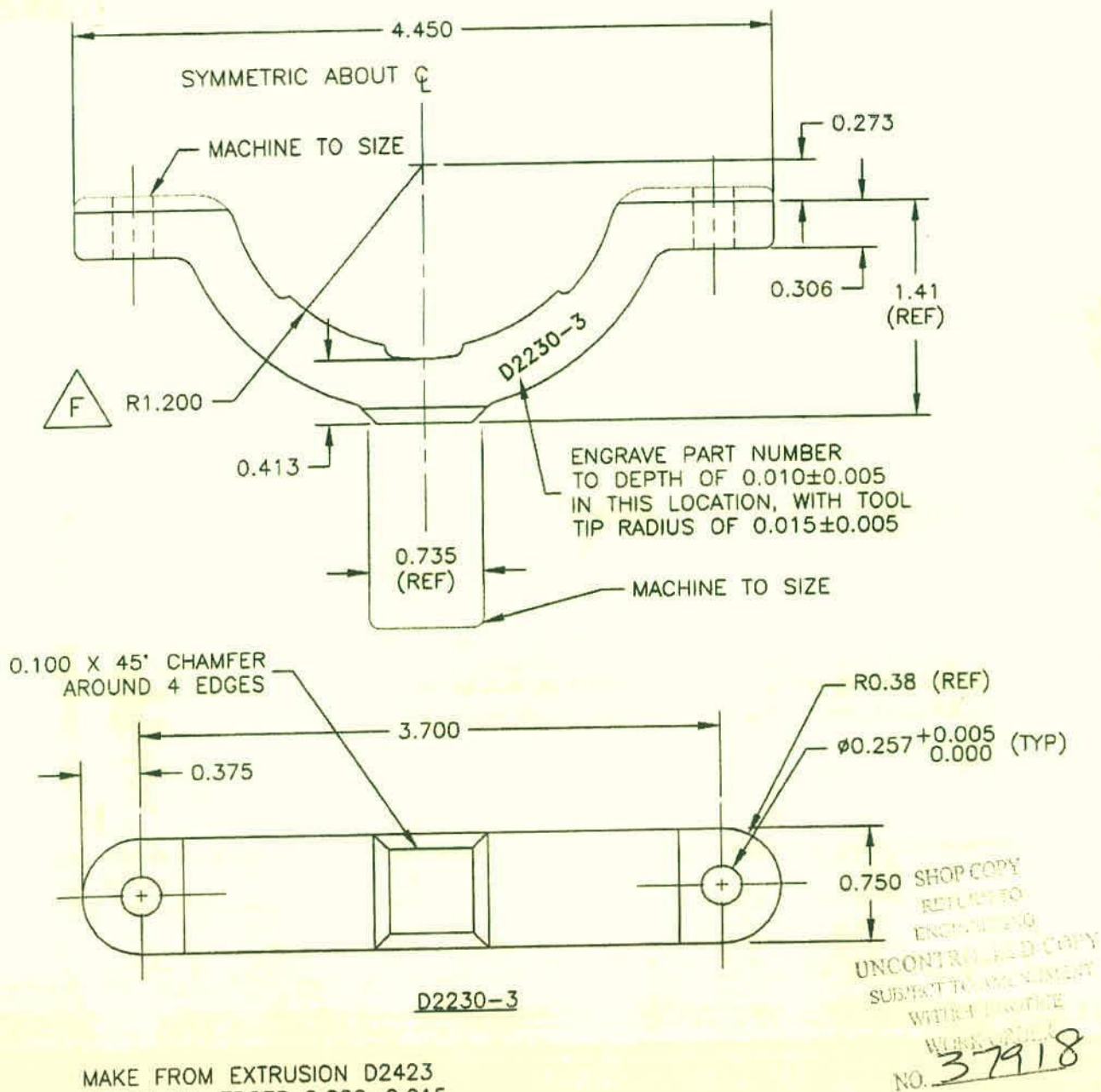






DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED  
99.12.21 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

49

D2230-3

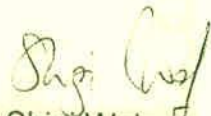
Mounting Lugs B37918

5918

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi Walz



Vankleek Hill, April 18, 2008

